

for blue

Work Order ID 62631

Tuesday, October 05, 2010 1:01:23 PM

Page 1

Item ID: D206-667-103TRN

Accept

Revision ID:

Item Name: Crosstube Turning DetailL

Start Date: 10/5/2010 Start Qty: 1.00

Required Date: 10/19/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: H

Date: 10/10/05 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

0.00

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087□2-Turn first side as per Folio FA087□3-File down transition lines smooth.

SA 10/10/20

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Quality Control

Memo

0.00

SA 10/10/20

120

0.00



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

0.00

1-Turn second side as per Folio FA087□2-File down transition lines smooth.
□
3-Remove sand and plugs

SA 10/10/20

1 0

1 0

1 0

W/O:		WORK ORDER CHANGES					
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Page 2

Item ID: D206-667-103TRN

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Setup Start



Revision ID:

Item Name: Crosstube Turning DetailL

Stop



Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

SA 10/10/20

1 2

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 10/10/20

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

SAD
10-10-21

1

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Picklist Print

Tuesday, October 05, 2010 1:01:27 PM

Page 1

Work Order ID: 62631



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL

Start Date: 10/5/2010

Required Date: 10/19/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6002-115		Manufactured	No			110	Each	50.0000	1	1			
												SA 10/10/20	
Crosstube Material													

Location

Loc Qty

Loc Code

LG	50	
34684	1	
34776	49	

1	SA

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DART AEROSPACE LTD	Work Order:	62431
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	/		
	1.982	+0.005/-0.000	1.982	/		
	2.019	+0.005/-0.000	2.019	/		
	2.058	+0.005/-0.000	2.060	/		
	2.097	+0.005/-0.000	2.101	/		
	2.136	+0.005/-0.000	2.132	/		
	2.176	+0.005/-0.000	2.180	/		
	2.201	+0.005/-0.000	2.205	/		
	0.125	+/-0.010	.125	/		
	0.400 x 30°	+/-0.010	.400 x 30°	/		
	R0.063	+/-0.010	R.063	/		
	R0.500	+/-0.010	R.500	/		
	4.438	+/-0.030	4.442	/		
SIDE B	104.98	+/-0.020	105.0	/		
	2.240	+0.005/-0.000	2.243	/		
	1.982	+0.005/-0.000	1.984	/		
	2.019	+0.005/-0.000	2.024	/		
	2.058	+0.005/-0.000	2.065	/		
	2.097	+0.005/-0.000	2.102	/		
	2.136	+0.005/-0.000	2.140	/		
	2.176	+0.005/-0.000	2.181	/		
	2.201	+0.005/-0.000	2.205	/		
	0.125	+/-0.010	.125	/		
	0.400 x 30°	+/-0.010	.400 x 30°	/		
	R0.063	+/-0.010	R.063	/		
	R0.500	+/-0.010	R.500	/		
	4.438	+/-0.030	4.443	/		

Measured by:	SA	Audited by:	SL	Preliminary Approval:	N/A
Date:	10/10/20	Date:	10/10/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	AM

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Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
REVISION
ENGINEERING
UNCONTROLLED
SUBJECT TO
WORK IN PROGRESS
NO. 62631-
PS 10-10-05

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-143	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DE APPR.	RF	DATE 08.11.06	
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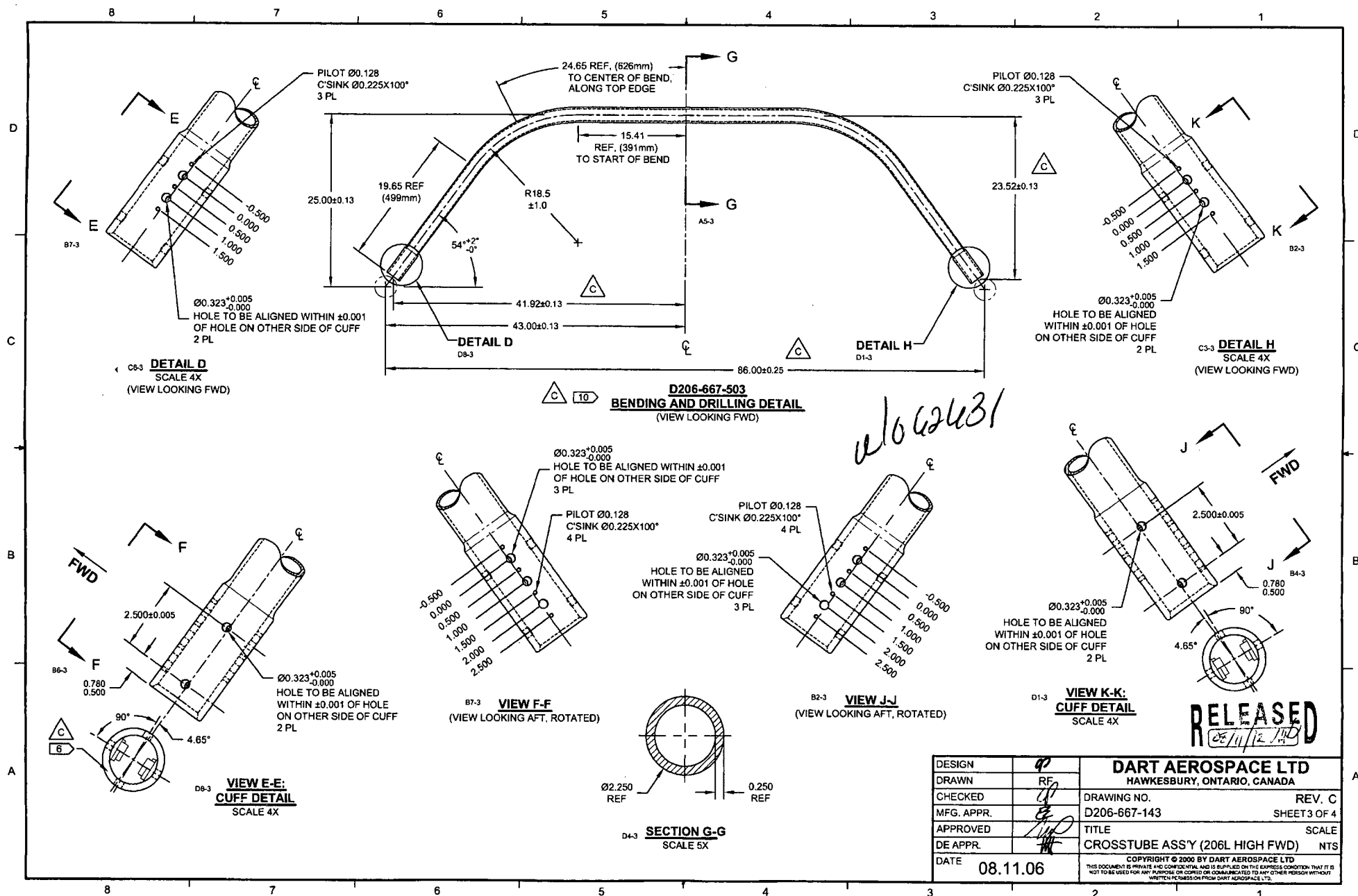
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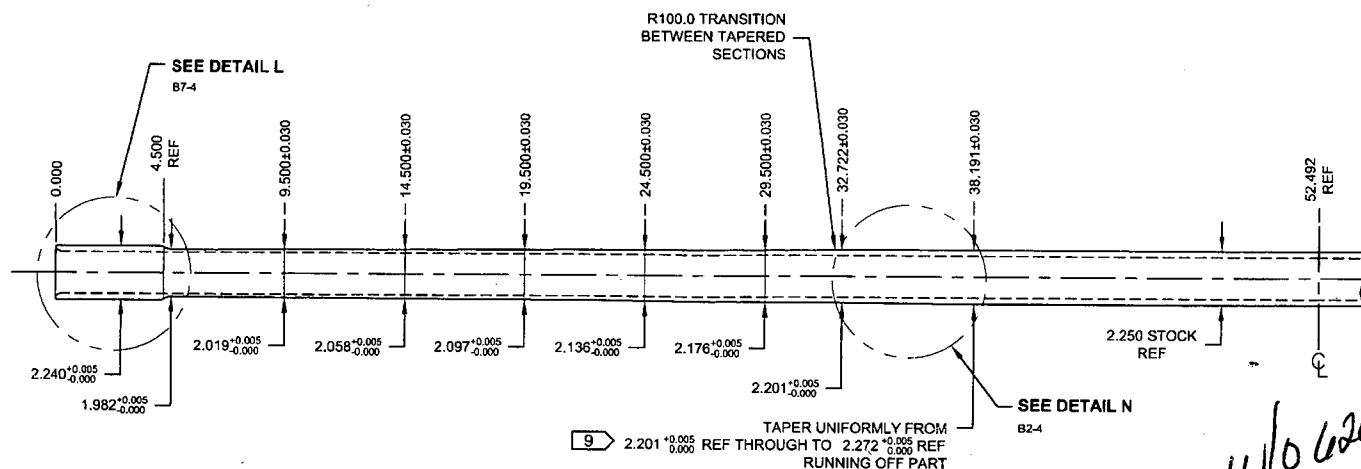
8 7 6 5 4 3 2 1

D

C

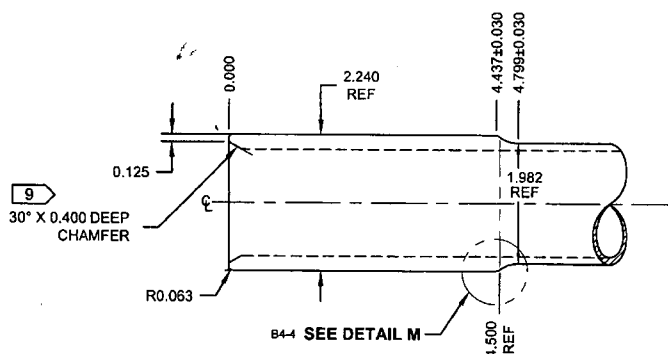
B

A

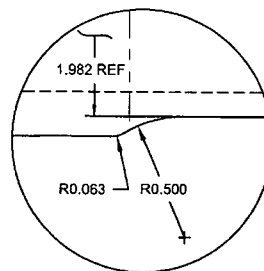


W/O 62631

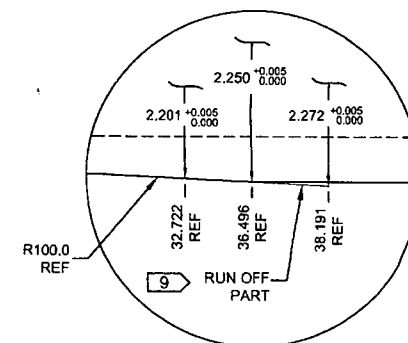
TURNING DETAIL



DETAIL L:
D7-4 CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
A6-4 CUFF TRANSITION
NOT TO SCALE



DETAIL N:
C4-4 TAPER RUN-OFF
NOT TO SCALE

RELEASED

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.	GP	D206-667-143	SHEET 4 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	H	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

D

C

B

A

8 7 6 5 4 3 2 1

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